



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-B-1A

Job Sheet 192195



Part No: RBE350A94-3700-B-1A

Job Qty: 30 pcs

Part Name: Short Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 4/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-B Rev. 6 IPP Rev. A 18.08.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	30 pcs	4/5/19	4/5/19	0.00	3.00	Small Fab - 1		<i>fred 19-4-11</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
		pcs	4/5/19	4/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
		pcs	4/5/19	4/5/19	0.00	0.00	Packaging 3 - 1 - B4B		<i>APR 15 2019</i> DAS 40 988
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartero.com
www.dartaerospace.com



Container No: S171891



Part: RBE350A94-3700-B-1A

Job No: 192195

Serial No/Batch: S171891

Revision: 6

Inspector:

Exp Date:

Date: 04/11/19

Instructions:

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	30 pcs	4/5/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	3-39

APR 15 2019

Part Op 110 - (Small Fab) 1-Assemble as per DWG. See note 1.
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	46 60 Ea (2 ea)	110-Small Fab - 1	5161581
92905A225	Extended Point Set Screw, Dog Point	23 30 Ea (1 ea)	110-Small Fab - 1	5051496(110) 5126
CL-2-C	Lanyard Wire	19.150 24.9900 ft (.833 ea)	110-Small Fab - 1	5119833
NAS1756-12	Remove Before Flight	23 30 Ea (1 ea)	110-Small Fab - 1	5134216
RBE350A94-3700-B-01	Tube	23 30 pcs (1 ea)	110-Small Fab - 1	51927167
RBE350A94-3700-B-03	Cap	23 30 pcs (1 ea)	110-Small Fab - 1	5167959
RBE350A94-3700-B-05	Foot	23 30 pcs (1 ea)	110-Small Fab - 1	5167860

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3896T31	60	635	0
	92905A225	30	92	0
	CL-2-C	25	299	0
	NAS1756-12	30	280	0
	RBE350A94-3700-B-01	30	4	0
	RBE350A94-3700-B-03	30	0	0
	RBE350A94-3700-B-05	30	0	0

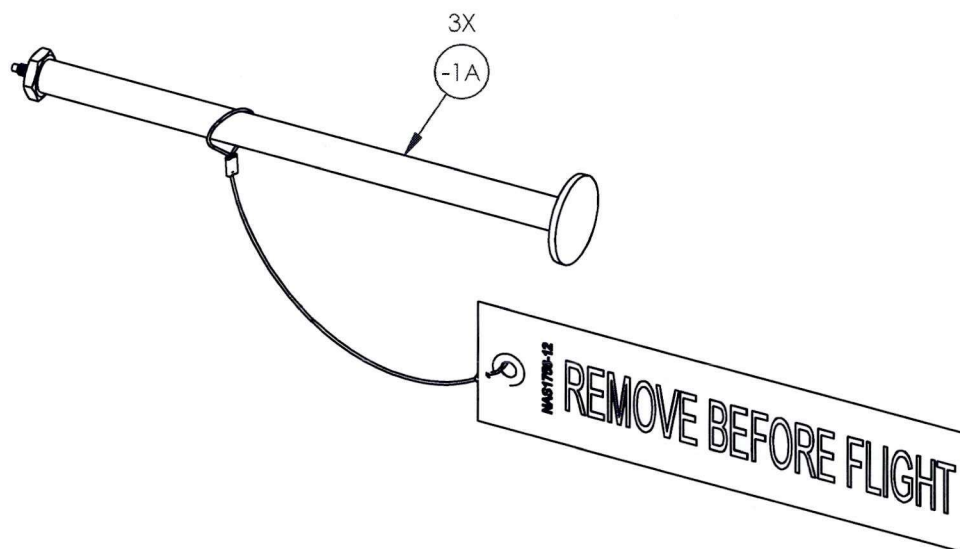
Part Specifications

Specifications could not be found.

Plex 3/28/19 1:51 PM dart.leclair.mathieu

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	8/21/2012	RJC	RW
5		CH'D T/N WAS RBEA94-3700-B IS RBE350A94-3700-B. -01 CH'D DIM WAS Ø.75 IS (Ø.75), WAS .083 IS (.083). -03 CH'D DIM WAS Ø.570 V .079 IS Ø.570, ADDED DIM Ø.586 P.F. -01, (Ø.20). -05 CH'D DIM WAS Ø2.00 IS (Ø2.00), WAS Ø.586 P.F. -05 IS Ø.586 P.F. -01. CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/23/2014	DPD	RJC
6	16-0151	UPDATED TO NEW DRAFTING STANDARD. DELETED P/N B. ADDED P/N'S -1A, -09, -011, -013. CH'D -07 DESCRIPTION WAS SOCKET HEAD SET SCREW DOG POINT IS SOCKET HEAD SET SCREW EXTENDED POINT. -1A ADDED DRAWING. -01, -03, -05 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. -01 CH'D DIM WAS (Ø.75) IS Ø.75, WAS (.083) IS .08. ADDED DIMS Ø.6047/.6040 (P.F. -03), Ø.6047/.6040 (P.F. -05), .88, .88, 2X .03 X 45°. ADDED ENGRAVE NOTE. -03 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01). -05 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01), WAS (Ø2.00) IS 2.00, CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	2/24/2017	RJC	SM

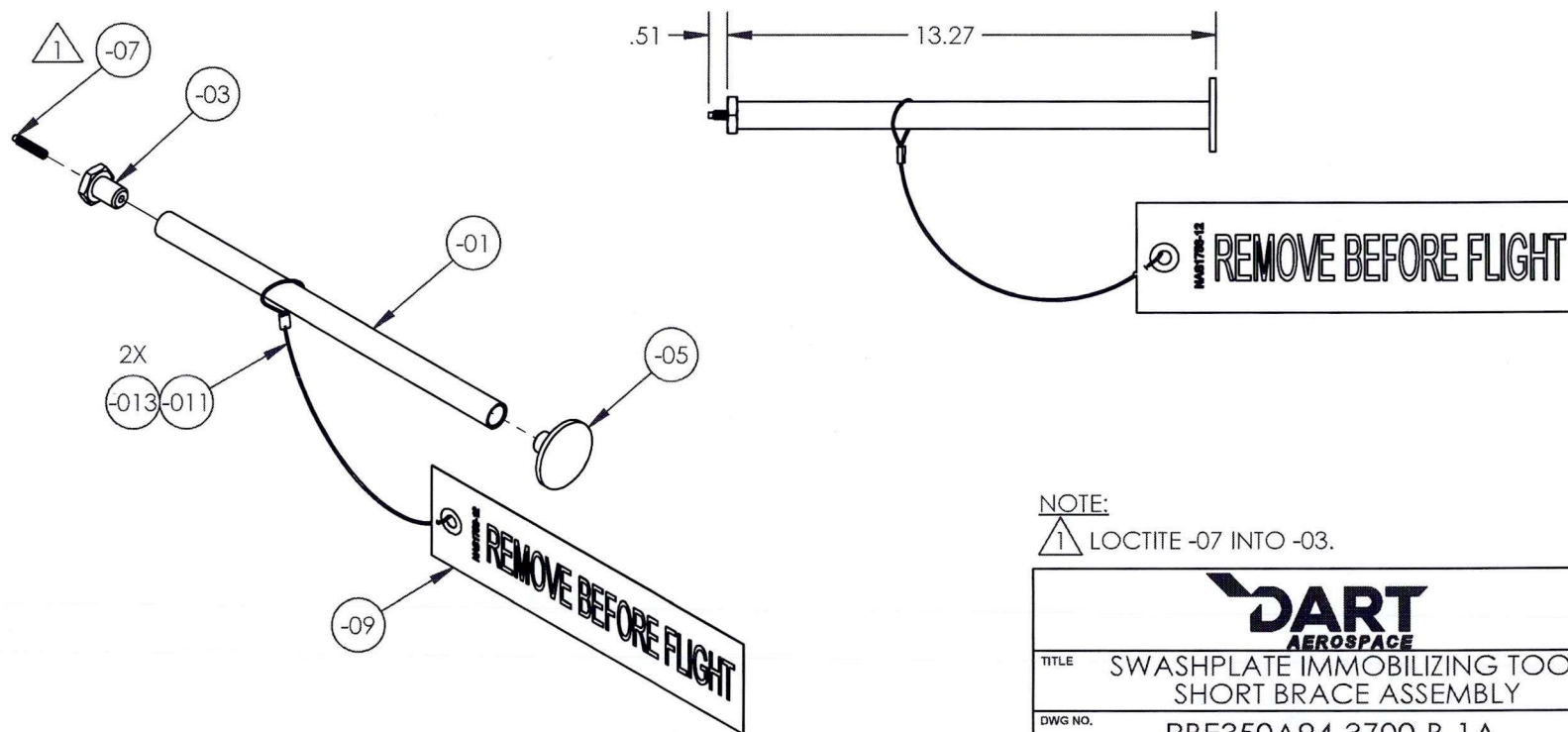


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3	SHORT BRACE ASSEMBLY			2
	1		-01		TUBE	STEEL		3
	1		-03		CAP	SP HEX		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		SOCKET HEAD SET SCREW, EXTENDED POINT	STEEL	M6 X 1 X 30mm (MCMaster-CARR #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-011		LANYARD CABLE	COATED STEEL	Ø1/16 X 8 [CARR LANE #CL-2-C]	2
	2	B/O	-013		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	ASSY -1A							

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY	
DWG NO. RBE350A94-3700-B	REV 6
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:4	DATE 8/21/2012 SHEET 1 OF 5

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	16-0151	-1A ADDED DRAWING.	2/24/20107	RJC	SM



NOTE:

1 LOCTITE -07 INTO -03.

SHORT BRACE ASSEMBLY

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY	
DWG NO. RBE350A94-3700-B-1A	REV 6
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:5	DATE 8/21/2012
	SHEET 2 OF 5